

Date: Thursday, 22/01/2009 7:53:01 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT T-HANDLE ASSY
Job Number	: 45023		
Estimate Number	: 13529		
P.O. Number	:	Part Number	: PB674300163
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.15
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 43053	Material	:
Written By	:	Due Date	: 28/01/2009 Qty: 8 Um: Each
Checked & Approved By	: <u>MF 09-01-22</u>		
Comment	: Est Rev:A 08-07-29 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001131	Tube End Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Tube End Cap

batch: 41480 x 12 mx 15520 x 4MF 09-02-12

2.0	PB6743001129	Tube Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tube Handle

batch: B 40019 x 4 mx B 45002 x 4MF 09-02-12

3.0	PB6743001127	Handle Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Handle Arm

batch: B 41479 x 6 mx 2 x B 43327MF 09-02-12

4.0	PB6743001157	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tube

batch: B 40026 x 4 mx 43390 x 4MF 09-02-12

5.0	CR321342	Cherry Rivet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Cherry Rivet

batch: m 102569MF 09-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 45023

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg

Handwritten: 09-02-16

8

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 09-02-17

8

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 09-02-18

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Handwritten: m 18/44

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat****
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

Handwritten: 1:40

OVEN TEMPERATURE:

Handwritten: 320°

FINISH TIME:

Handwritten: 2:10

Handwritten: 09/03/03

Handwritten: 8

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 09-03-3

Handwritten: 8

11.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

SPRING SLOTTED PIN

batch:

Handwritten: M17850

Handwritten: 9/3/4

Handwritten: 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 7:53:02 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 45023

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PB6743001133

Clevis



(P70) →

Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Clevis

batch: 523994 B45001 → 1

SP

13.0

PB6743001137

Locking Sleeve



(8X)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Locking Sleeve

batch: 44999 (6) 340023

9/3/4

SP

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(7)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble by drilling thru both -157 and -133 as per dwg

2- install spring slotted pin as per dwg

FL 09/03/05

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/06 (48)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 444

SS 09/03/06 (48)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10

Job Completion



mf 09-03-09

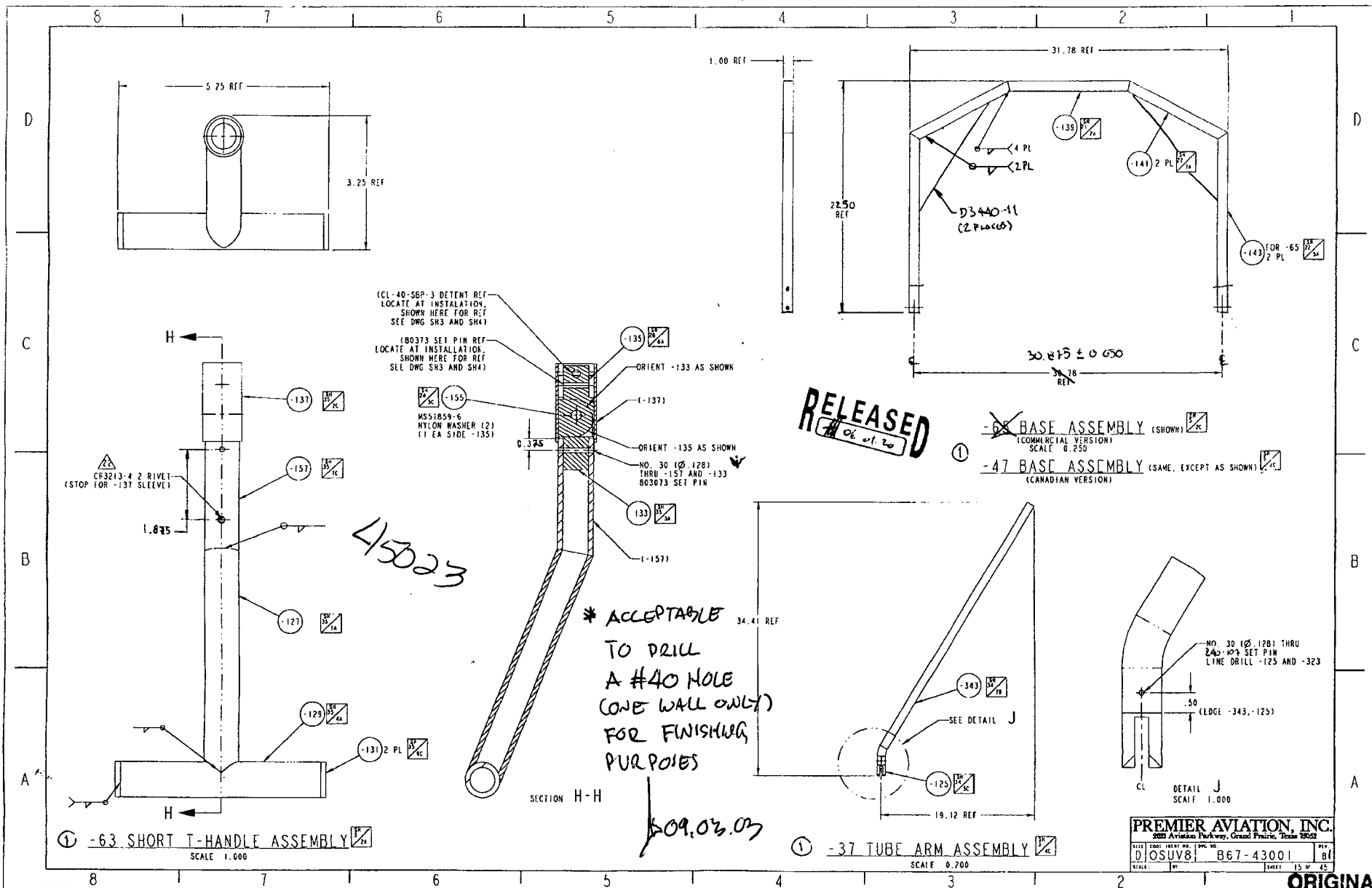


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-67 PAR #: N/A Fault Category: Prod / FAB. Lg NCR: Yes No DQA: D Date: 29/03/12
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: D Date: 09/03/12

NCR: <u>45023</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.03.05	120	PB67-43001-133 MOVED OUT AS SPRING PIN HOLE WAS DRILLED THROUGH -133 AND -163. R.C. LACK OF ATTN	09.03.05	SCRAP PB67-43001-133 PLUG LARGER HOLE IN PB67-43001-163. INSERT NEW PB67-43001-133 AND DRILL THRU BOTH PARTS.	09/03/05	09.03.10	09.03.05	09.03.10

NOTE: Date & initial all entries



1.845
3.15
2.240